

Work Order ID 76535

Wednesday, November 16, 2011 12:56:28 P

76535

Page 1

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/17/2011 Start Qty: 6.00

Required Date: 11/25/2011 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M C S

QC:

Date: 11/17/11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Reject Insp.
Number Stamp

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Work Order ID 76535

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Page 2

Item ID: D4095-043
Revision ID:
Item Name: Wearplate Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 11/17/2011 Start Qty: 6.00
Required Date: 11/25/2011 Req'd Qty: 6.00
Reference:

6
6

Cust Item ID:
Customer:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

1- bend section C-C first
2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

0.00

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Ensure joggle as per dwg D4095

0.00

150

150

Large Fab

Large fab

Weld per dwg A/R Hardcoat S.S. Batch
Large Fab

Memo

0.00

0.00

11-12-16 /BL **X4**

Work Order ID 76535

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Page 3

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/17/2011 Start Qty: 6.00

Required Date: 11/25/2011 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

Surf 12/16

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

Surf 12/16

(+4)

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG:
A/R ROCKGUARD BATCH 118000

11-12-18

Work Order ID 76535

Wednesday, November 16, 2011 12:56:28 P

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Page 4

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/17/2011 Start Qty: 6.00

Required Date: 11/25/2011 Req'd Qty: 6.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

BT 11-12-19

200

Identify as per dwg & Stock Location: FP-1

0.00

200

Packaging

Memo

0.00

Packaging

x6 of 11/12/19
counted & measured

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

11/12/19

11-12-19
(6)

Picklist Print

Wednesday, November 16, 2011 12:56:28

Page 1

Work Order ID: 76535

Parent Item: D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 11/17/2011

Required Date: 11/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A new issue DD 10.04.26 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	28.1000	2.275	14.368421			

Bill-u-18

Location

Loc Qty

Loc Code

MAT020

28.1

119346

28.1

119653

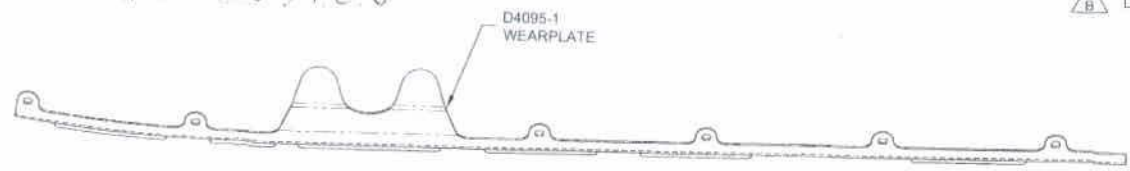
119653

(6)

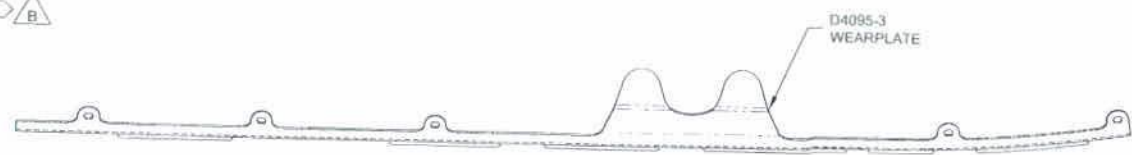
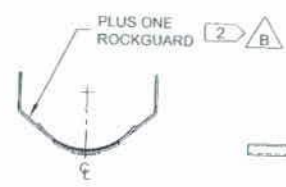
8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8	1						D4095-3	WEARPLATE
9		1					D4095-5	WEARPLATE
10			1				D4095-7	WEARPAD
11				1			D4095-9	WEARPAD
12					1		D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

710535 M.L.J



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY

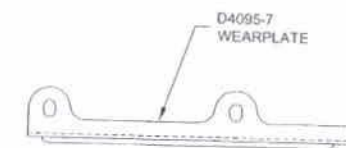
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

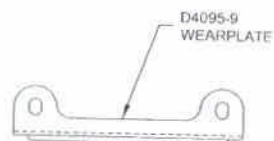
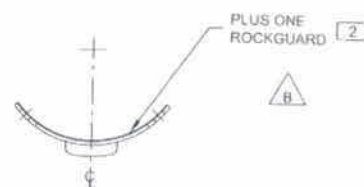
B	REVISED D4095-1/-1F/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN. REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MM	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF	DART AEROSPACE USA, INC KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 1 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
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8 7 6 5 4 3 2 1

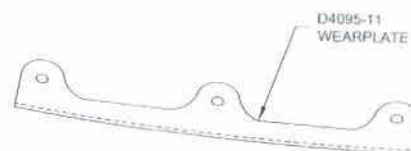
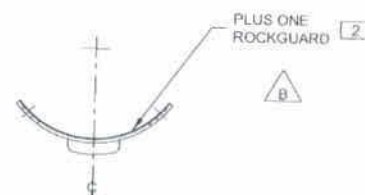
76535



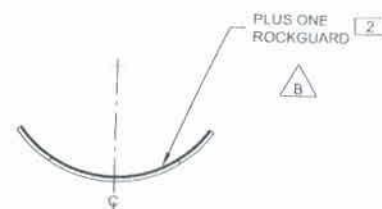
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



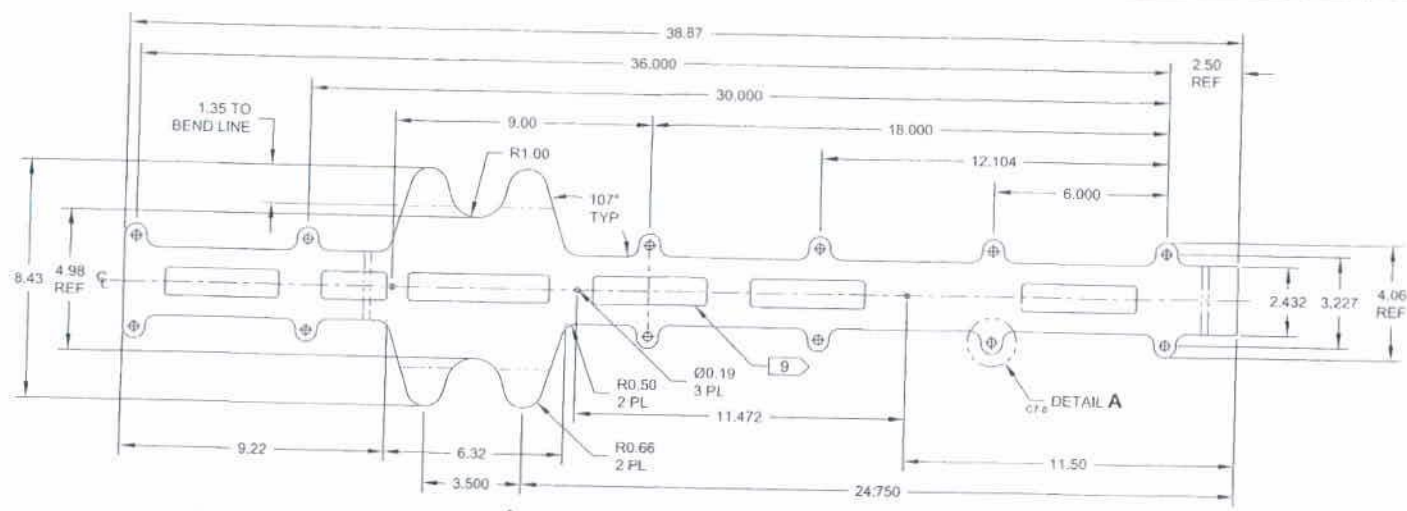
D4095-051 WEARPAD ASSEMBLY



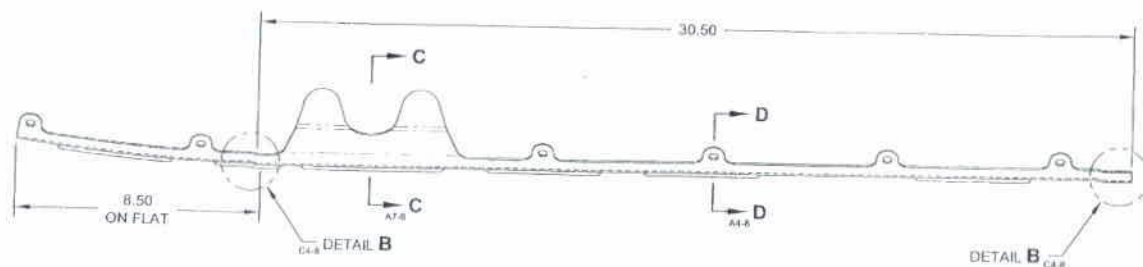
RELEASED
2011-10-31
JMP

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DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 2 OF 8
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70535



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

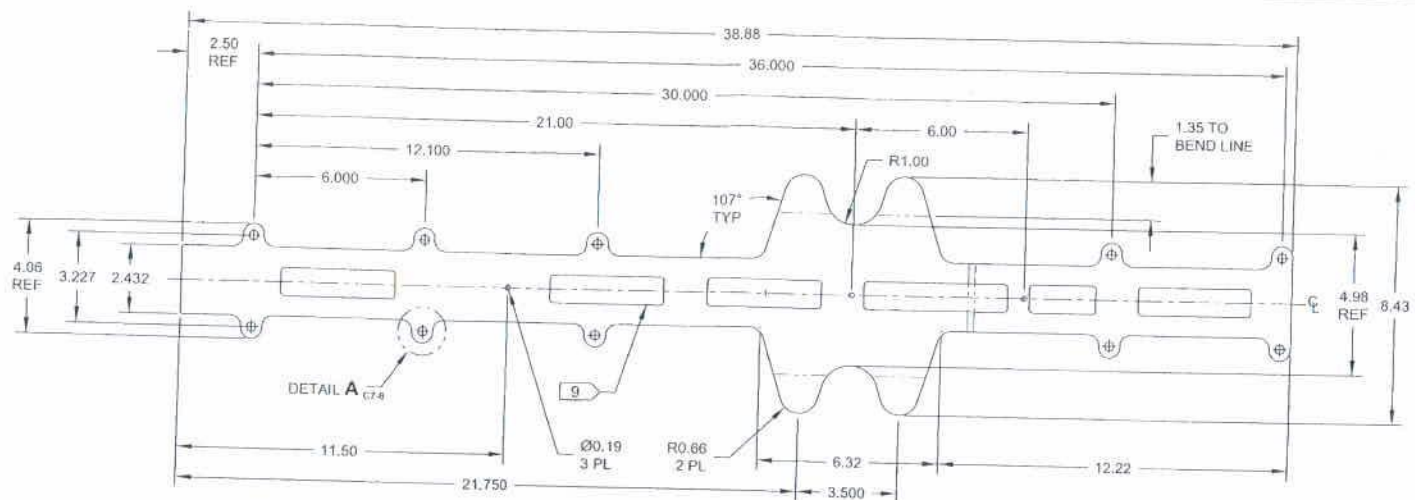
RE-DESIGNED
2011-10-31
WP

D4095-1/1F/1-3F/1-5F/1-7F/1-9F/11-11F NOTES:

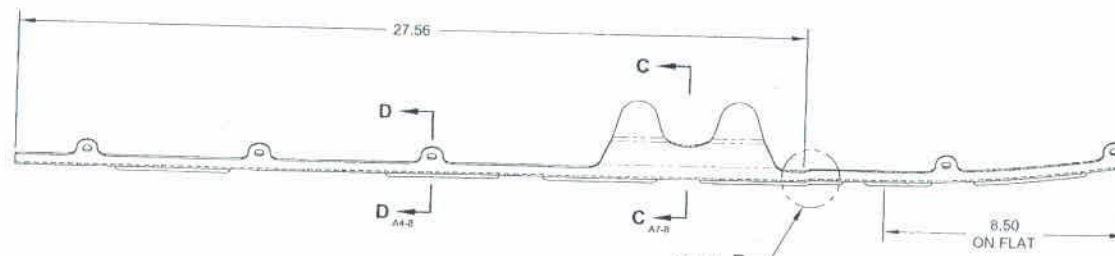
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

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D4095-3F FLAT PATTERN 1

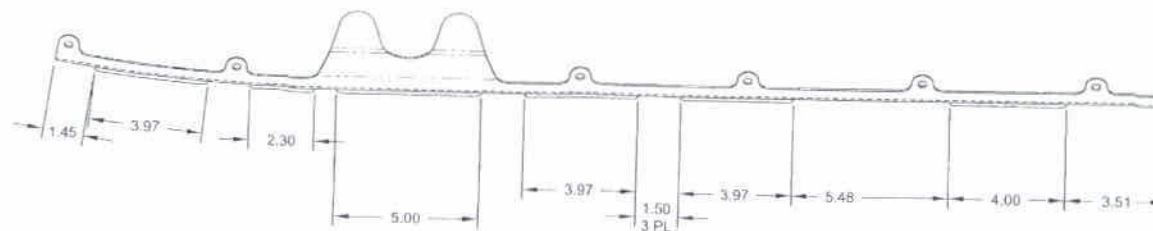


D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

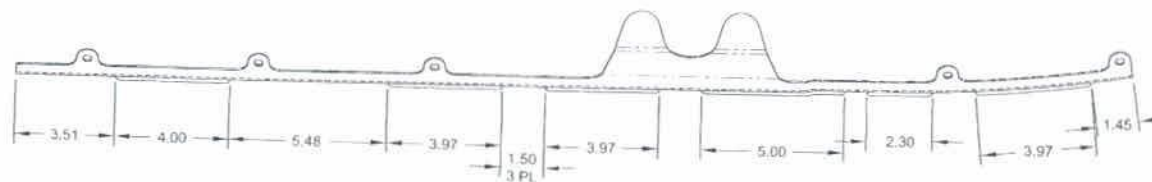
RELEASE
2011-10-31

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CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 4 OF 8
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D4095-1 WELDING DETAIL 

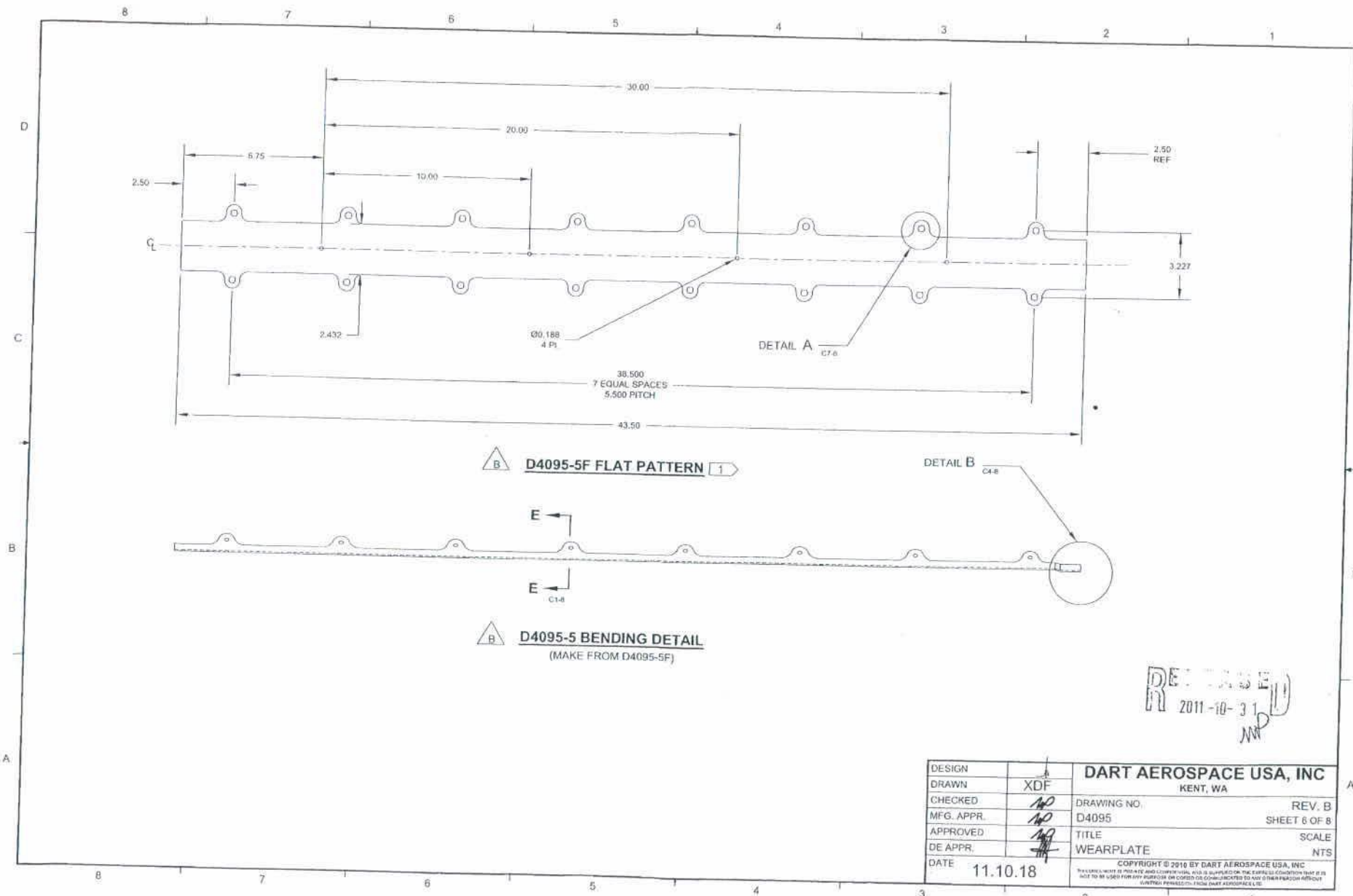


D4095-3 WELDING DETAIL 

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2011-10-31

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DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. B
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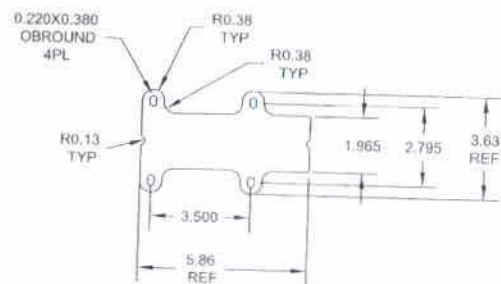
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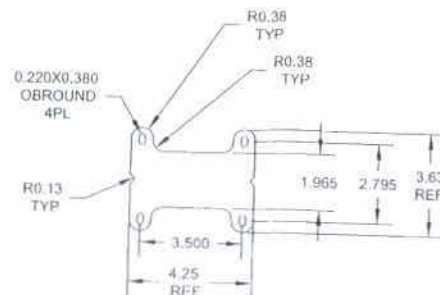
RECEIVED
2011-10-31
MD

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DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 6 OF 8
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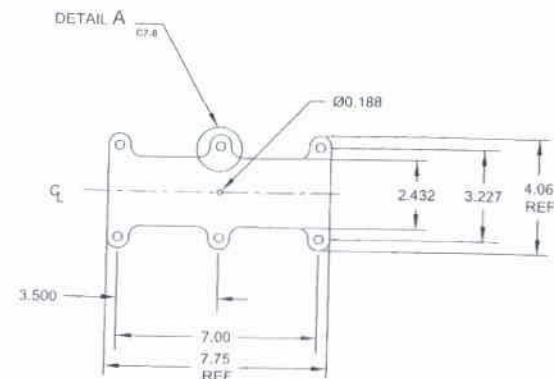
76535



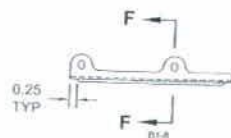
D4095-7F FLAT PATTERN



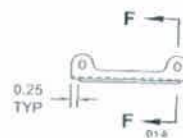
D4095-9F FLAT PATTERN



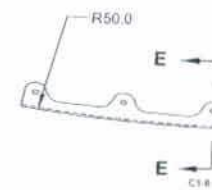
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MAKE FROM D4095-7F)



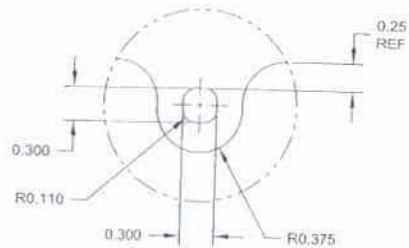
D4095-9 LONGITUDINAL BEND
(MAKE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AD	DRAWING NO.	REV. B
MFG. APPR	AD	D4095	SHEET 7 OF 8
APPROVED	AD	TITLE	SCALE
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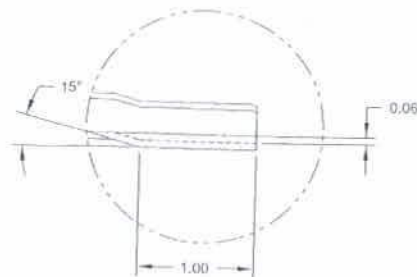
76535



DETAIL A: TAB DETAIL

SCALE 4X

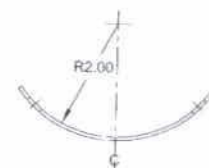
C3-3
C6-4
D5-6
D7-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

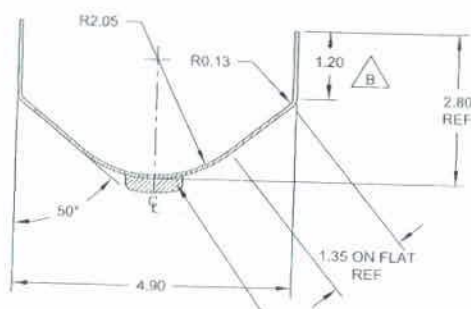
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

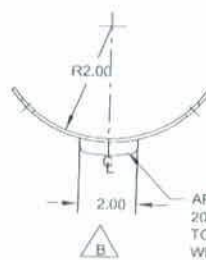


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

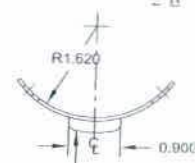


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-3
NP

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4095	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	

DART AEROSPACE LTD		Work Order:	76-535
Description: Wearplate		Part Number:	D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.192			V R02	
0.300	+/-0.010	.304			V	
0.300	+/-0.010	.306			V	
2.432	+/-0.010	2.436			V	
3.227	+/-0.010	3.228			V	
4.06	+/-0.030	4.053			V	
2.50	+/-0.030	4.053 2.50			V	
4.98	+/-0.030	4.98			V	
8.43	+/-0.030	8.414			PROW 32	
11.50	+/-0.030	11.50			P	
21.750	+/-0.010	21.750			T R01	
3.500	+/-0.010	3.500			V	
12.22	+/-0.030	12.22			T	
6.000	+/-0.010	6.00			T	
12.100	+/-0.010	12.100			T	
21.00	+/-0.030	21.00			T	
30.000	+/-0.010	30.000			T	
36.000	+/-0.010	36.000			T	
38.88	+/-0.030	38.88			T	
0.063	+/-0.010	.060			V	

Measured by: RB	Audited by: C	Preliminary Approval:
Date: 11-11-18	Date: 11/11/21	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	